

Date: Monday, 6/26/2006 3:46:30 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BASKET LID ASS'Y (A119)
Job Number :	27693A		
Estimate Number :	12445		
P.O. Number :	NIA	Part Number :	D3515041
This Issue :	6/26/2006	Drawing Number :	D3515 PRELIMINARY
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	NIA	Drawing Revision :	PRELIMINARY
Previous Run :	NIA	Material :	NIA
Written By :	Type :		LARGE FAB ASSY
Checked & Approved By :	Due Date :		7/3/2006
Comment :	Qty:		2x
	Um:		Each

EST rev. A 06.06.05 Preliminary EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22321	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: 25238

2.0	D31663	Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Basket Hoop

Batch: 825896

3.0	D23271	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: 26742

4.0	D2506	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: 26672-2

5.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: 826204

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/26/2006 3:46:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 27693A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: 1100283

AS

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 as per dwg D3516

2-Cut rib D3515-3 as per dwg D3516

3-Cut rib D3515-5 as per dwg D3516

4-Cut rib D3515-7 as per dwg D3516

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

AS

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

AS

9.0

QC5 19

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD

[Signature]

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: 1100999

AS

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/26/2006 3:46:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 27693A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

ml 6.06.28 (1)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: —

PD

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.20

Job Completion



U 06.07.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

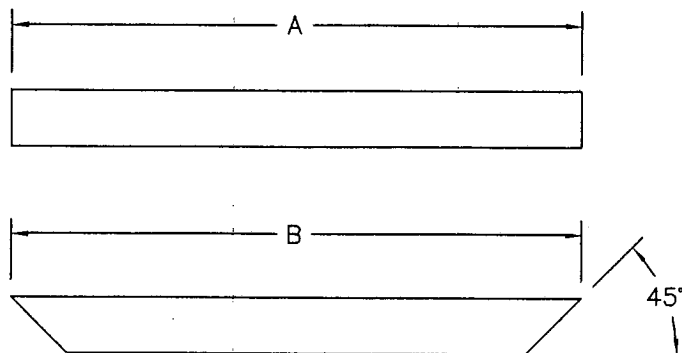
QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

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CHECKED	APPROVED	DRAWING NO. D3515	REV. - A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D3515-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

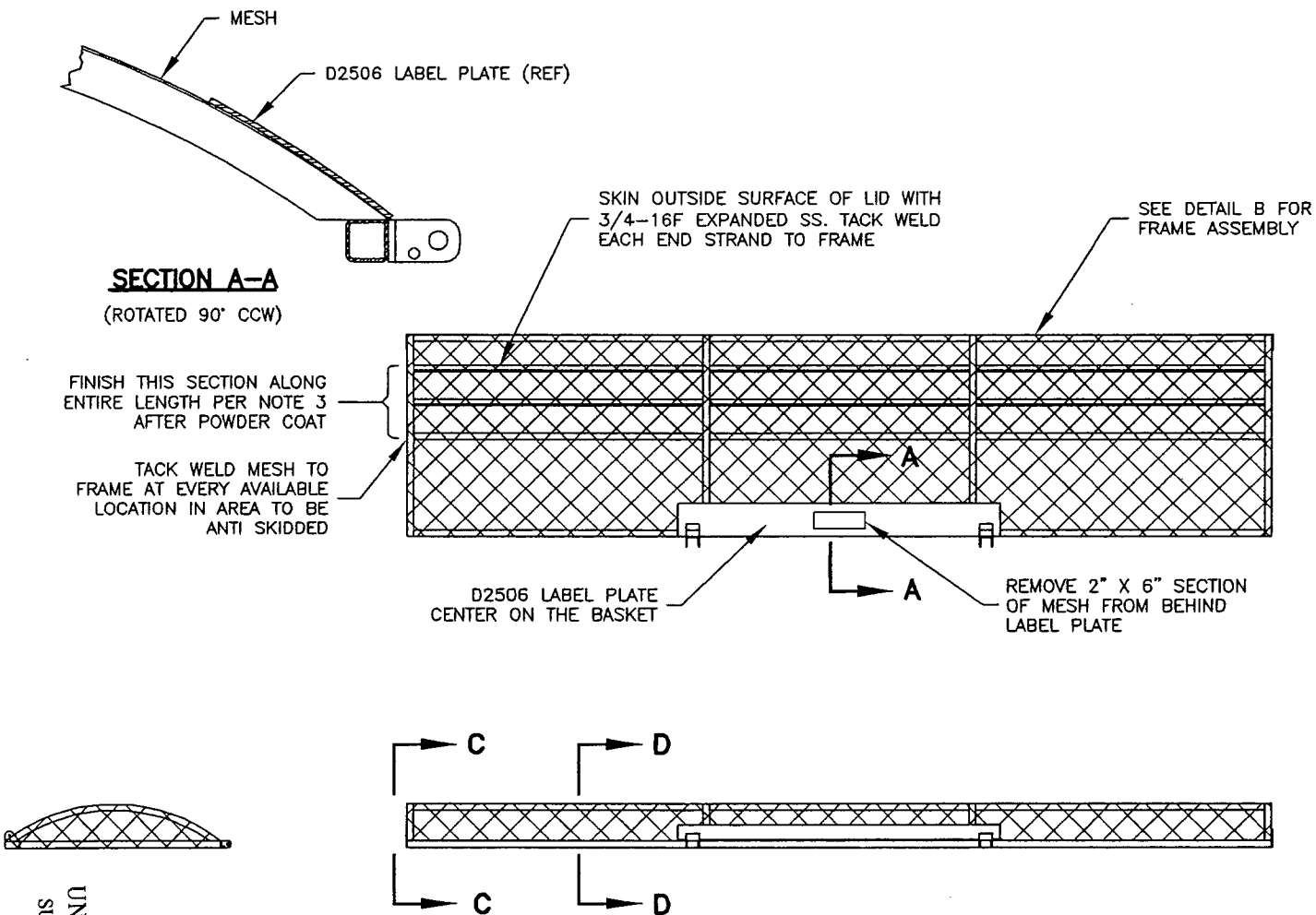
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WORK ORDER
NO. **27693A**

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DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 4
DATE		TITLE	SCALE
06.05.05		BASKET LID ASSEMBLY (A119)	1:20



D3515-041 BASKET LID ASSEMBLY

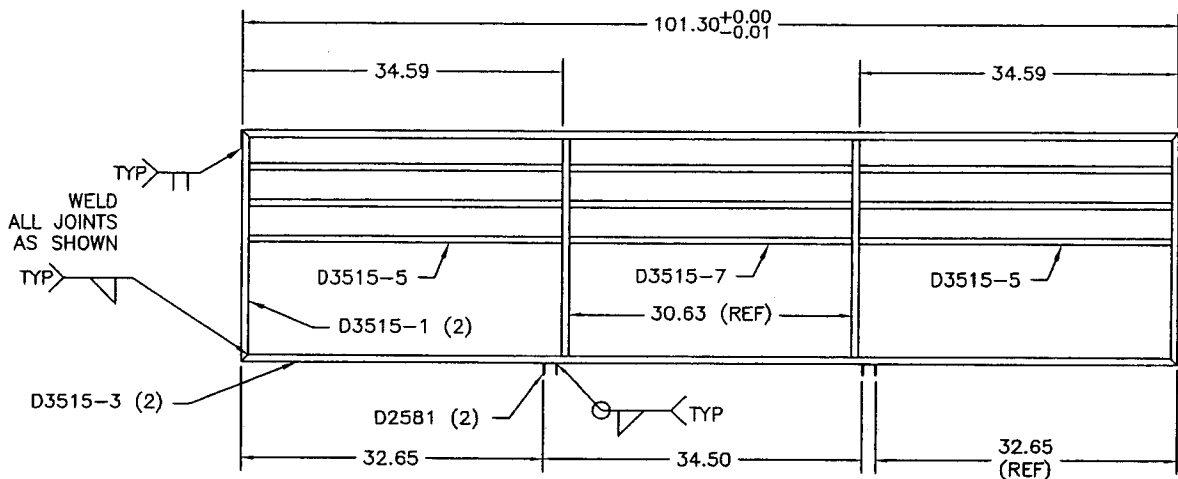
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. 27693A

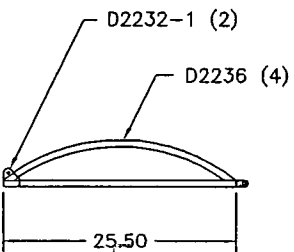
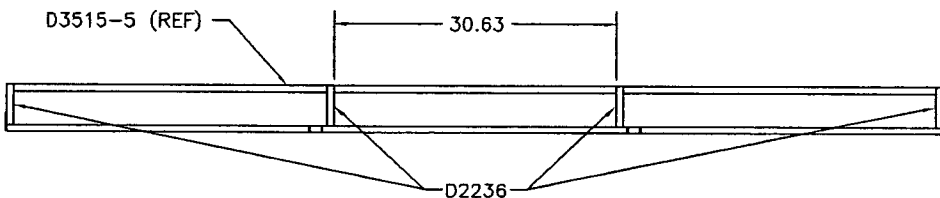
PRELIMINARY ISSUE

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CHECKED		APPROVED		DRAWING NO. D3515	SHEET 3 OF 4
DATE	06.05.05	TITLE	BASKET LID ASSEMBLY (A119)	SCALE	1:20



DETAIL B

FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

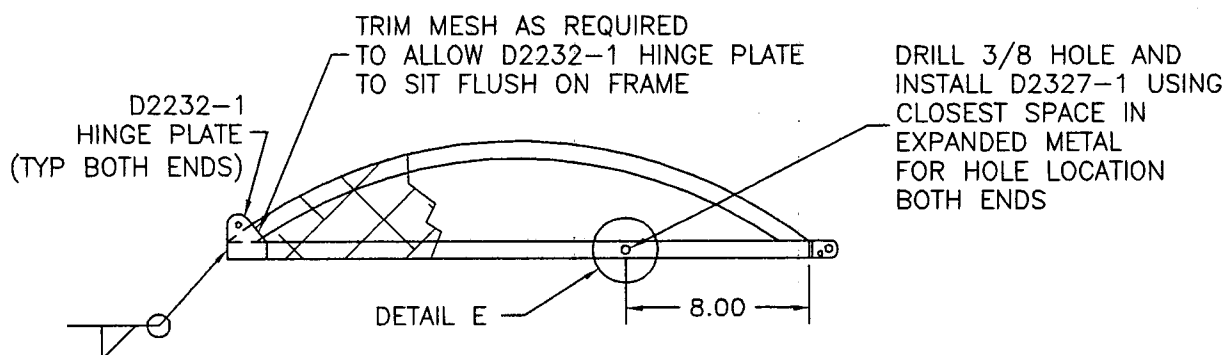


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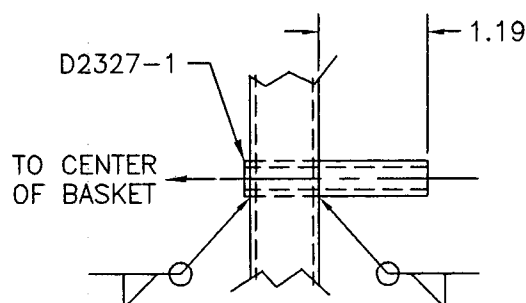
WORK ORDER
NO. 276934

PRELIMINARY ISSUE

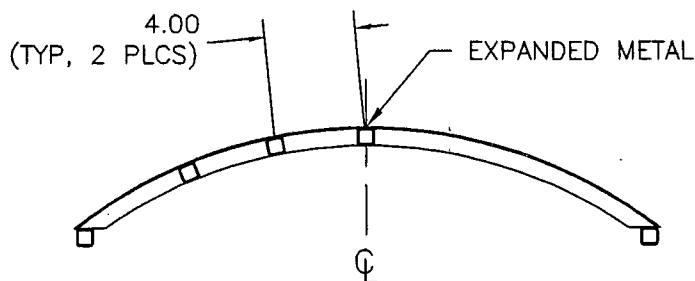
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CHECKED	APPROVED	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8



SECTION C-C SIMILAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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PRELIMINARY ISSUE

06.05.25

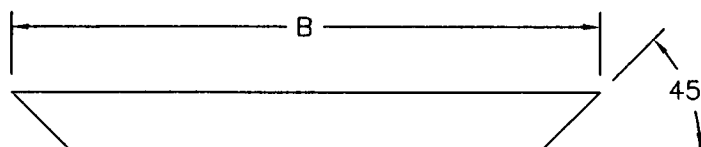
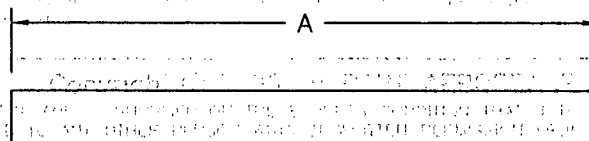
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CHECKED	APPROVED	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05	TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS	
A	06.05.05	NEW ISSUE	

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.05.25

11/2	N/A	HINGE PLATE
11/2	N/A	RIB
11/2	N/A	BUSHING
N/A	N/A	LABEL PLATE
N/A	N/A	MOUNTING BRKT

PARTS LIST FOR D3515 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D3515-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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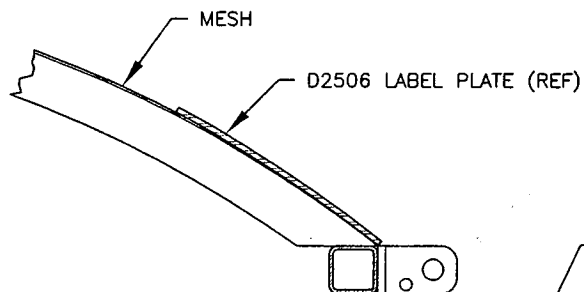
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06-05-25

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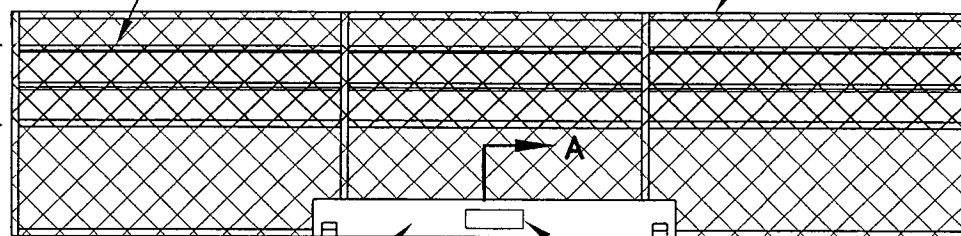
SECTION A-A

(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

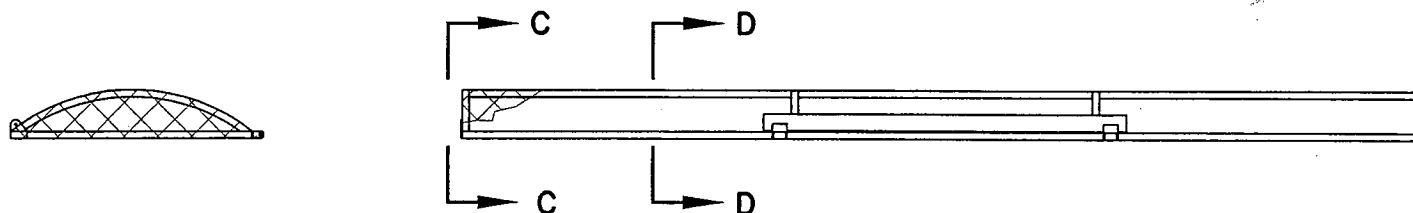
SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY



D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

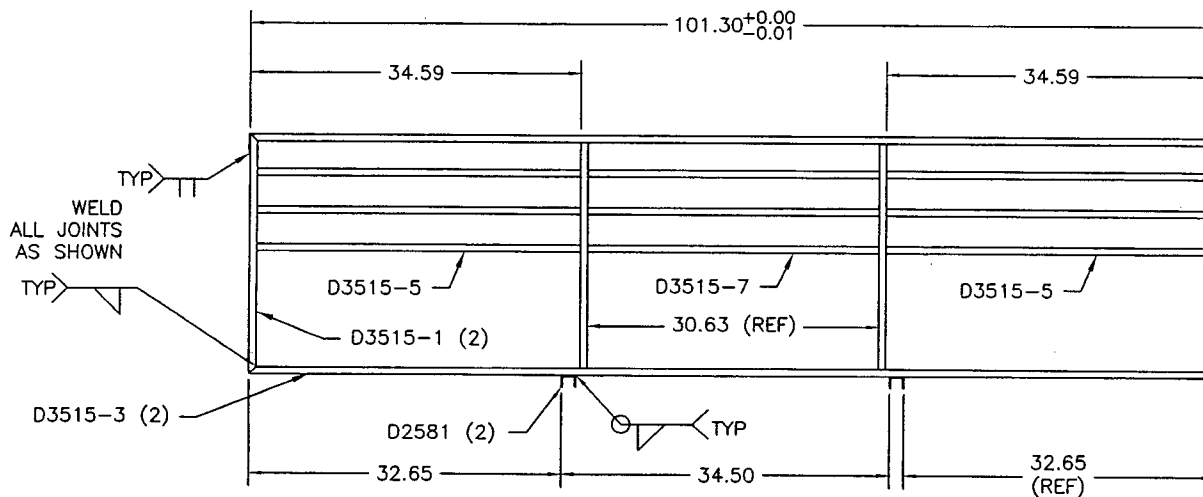
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DATE	DRAWING NO.	REV. A
06.05.05	D3515	SHEET 2 OF 4
	TITLE	SCALE
	BASKET LID ASSEMBLY (A119)	1:20

PRELIMINARY ISSUE

06.05.25

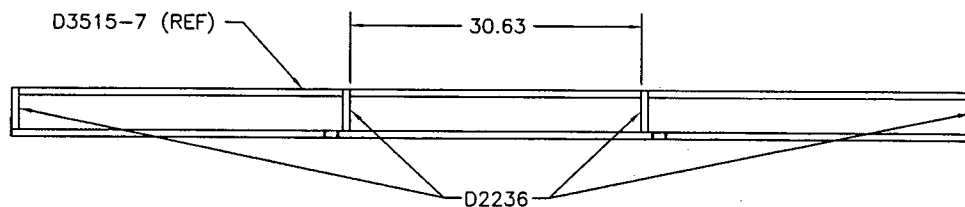
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DATE	DRAWING NO.	REV. A
06.05.05	D3515	SHEET 3 OF 4
	TITLE	SCALE
	BASKET LID ASSEMBLY (A119)	1:20

PTO

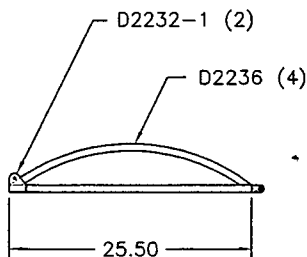


DETAIL B

FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



PROTOTYPE
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A2581 QTY ~~4~~ 4 B26204

A2232-1 QTY ~~4~~ 4 B25238

A2327-1 QTY ~~4~~ 4 B26742

B3166-1 QTY ~~2~~ 2 A25896

A2506 ~~QTY 1~~ QTY 1 B26031-2

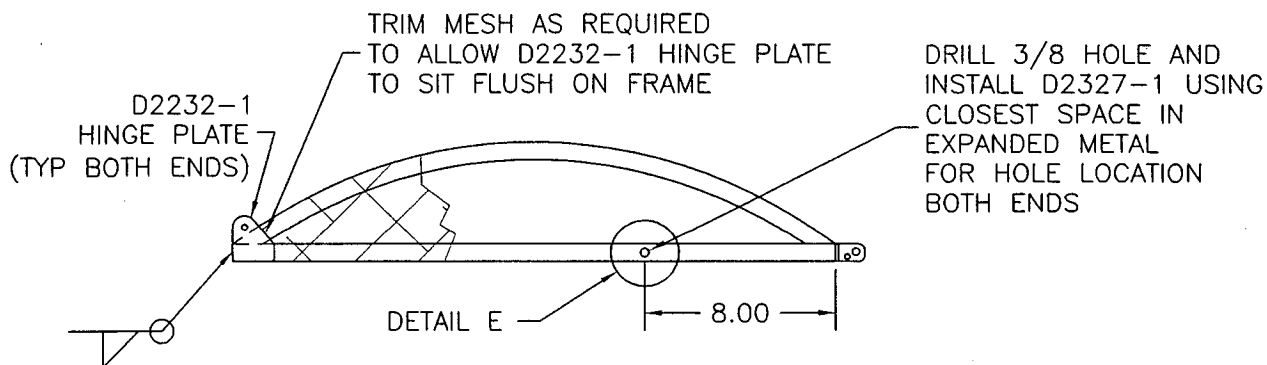
$\frac{3}{4}$ " x $\frac{3}{4}$ " x $\frac{1}{2}$ " wall 304/316 SS Tubing M100783

* Had to scrap Lid and make one more
Parts and Tubing

PRELIMINARY ISSUE

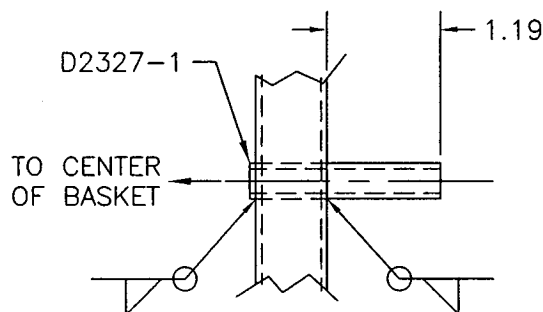
06-05-25

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3516	REV. A SHEET 4 OF 4
DATE 06.05.05	TITLE BASKET LID ASSEMBLY (A119)		SCALE 1:8

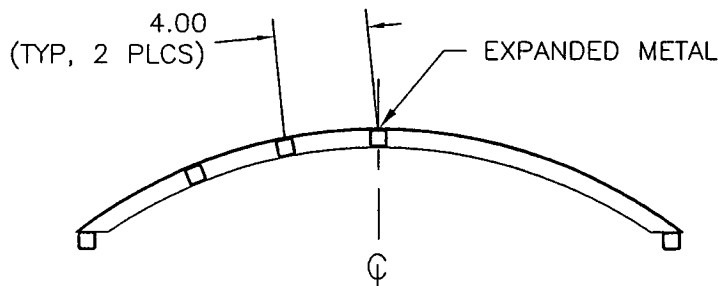


SECTION C-C SIMILIAR BOTH END RIBS

PROTOTYPE
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06-05-25



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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